

Date: Monday, 17/11/2008 1:53:12 PM
User: Julie Dawson

Process Sheet *Split*

Drawing Name : 206L1407 STEP ASSY, LH

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 43489A -2

Estimate Number : 11702

P.O. Number :

This Issue : 17/11/2008 S.O. No. :

Prsht Rev. : NC

First Issue : // Type : LARGE FAB ASSY

Previous Run : 40926A

Written By :

Checked & Approved By : *JUD 08.11.17*

Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Part Number : D2724041

Drawing Number : D2724 REV C

Project Number :

Drawing Revision : C

Material :

Due Date *shd* 02/02/2009

Qty: *Split 3* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion *42155*

Check Material for any Dents or Defects

SAD 08-12-29 (4)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

SAD 08-12-29 (4)

3.0 D2734 Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch

2 D2734 End Cap *339179*

4.0 D34581 Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3458-1 Plate *343085=1*

844002=1

08-12-30 4

Date:
User:

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Customer: CU-DAR001 Dart Helicopters Services

Job Number: 43489A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34583

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description
2 D3458-3 Plate

Batch

343084=6 B 44003=2 18.02.12.30 4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch: 17105037
17109560

Grind end cap welds flush

18.09.1.05 4
18.09.1.05 4

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

21E 09-01-06 4

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

29/01/06 (x4 LH)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Sam 09-01-06 (4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19.01.09 4

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

19.01.09 4

ate:
user:

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Process Sheet

Drawing Name: 206L 1407 STEP ASSY, LH

Customer: CU-DAR001 Dart Helicopters Services

Job Number: 43489A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: M102037

Grind per dwg D2724

Handwritten: 09.01.09 4
09.01.09 4

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 09-01-09 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 09/01/09 (4) CAI

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Handwritten: 4X

Touch up Alodine

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME -GREY

-SPRAY PAINT DELFLEET BLUE

-CLEAR DELFLEET

B 110194
B 110077
B 110161

Handwritten: RT 09-01-12

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

Handwritten: ml 09 01 13 (1)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 54.4

Handwritten: M10454

Handwritten: 09.01.16 (4)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 09-01-19 (X3)

Date: Monday, 17/11/2008 1:53:12 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 43489A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



32

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

43489

9/1/08

Sep

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mr
09-01-29

